

AMENDMENT UNDER 37 C.F.R. §1.111
USSN: 10/014,516

AMENDMENTS TO THE SPECIFICATION

Please replace the paragraph bridging pages 5 and 6 with the following:

A Then, after the tension of the web is progressively increased at a predetermined rate, the tension is reduced at a predetermined rate while the web is being wound around the core. The web is thus wound around the core to which ~~sufficiently~~ sufficient rigidity is imparted, without being subjected to an excessive load. As a result, a roll produced by winding the web around the core is free of edge undulations or irregularities on its end faces, and is of a good quality free of damage and winding irregularities.